



Work Order ID 73293


Wednesday, August 31, 2011 10:43:47 AM


Page 1


Item ID:	D2576-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Step (casting detail)					
Start Date:	9/1/2011	Start Qty:	50.00		Cust Item ID:	
Required Date:	9/15/2011	Req'd Qty:	50.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>CL</u>	Date:	<u>11/09/01</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2576	Rev G								

100		0.00							
	PURCHASING								<u>CL 11/09/01 50</u>
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>14795</u> Ship D2576 mould to vendor Cast per D2576-1 Pattern vendor: Alpine Non- Ferrous Material Release Note Required								

110		0.00							
	Receive & Inspect for Damage & Mat'l Certs								<u>CL 11/09/20 50</u>
Packaging	Memo	0.00							
Packaging	Ensure D2576 mould is returned with the ordered parts Ensure release note is attached								

120		0.00							
	QC6- Inspect dimensions to drawing								<u>Counts</u>
QC	Memo	0.00							<u>XSD</u>
Quality Control	<u>8/10/12</u> <u>OSP019</u>								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73293

Wednesday, August 31, 2011 10:43:47 AM



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Item ID: D2576-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Step (casting detail)

Start Date: 9/1/2011 Start Qty: 50.00



Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 50.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Memo

0.00

0.00

Packaging

*CNC
Cell**Jim 11-09-26.*

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

*11/9/27
ME
11-09-28*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

- Wednesday, August 31, 2011 10:43:44 AM

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Work Order ID: 73293



Parent Item: D2576-1



Parent Item Name: Step (casting detail)


Start Date: 9/1/2011

Required Date: 9/15/2011

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev: A New Issue 05-11-29 JLM
IPP rev B rev F dwg 07.07.06 EC
IPP Rev:C As per Rev G 07-09-05 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2576-1P  Step (Casting Detail)		Purchased	No			100	Each	0.0000	1	50		8/31/2011	50

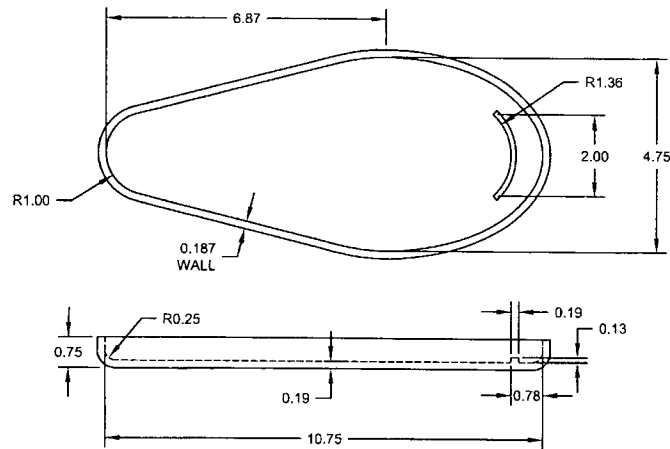
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector,

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

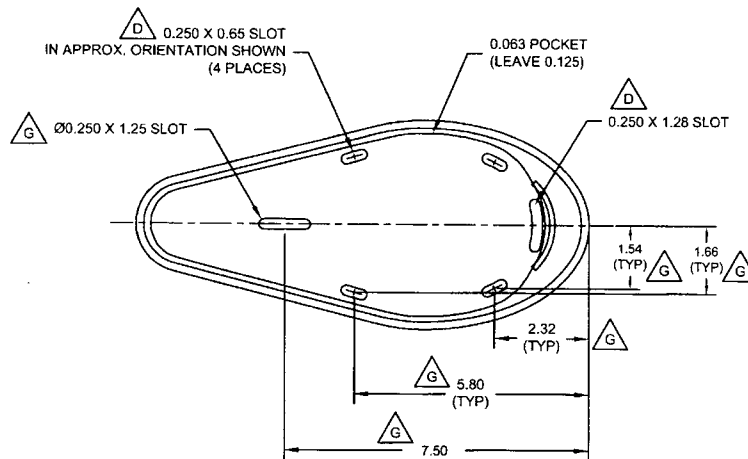
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2576-1 CASTING



D2576-3 MACHINING DETAIL
(MAKE FROM D2576-1)

NOTES:

- 1) MATERIAL: CAST ALUMINUM ALLOY A-535.2
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.025 TO 0.050 MAX
- 6) IDENTIFICATION: NONE

c211/09101
W10.73293

RELEASED

07.08.21

G	- CHANGE SLOTS LOCATION AND SIZE ON D2576-3 - DUE TO SKID BENDING PROGRAM CHANGES - UPDATE CNC PROGRAM	MB	07.08.15
F	7.05 WAS 6.61	PH	07.04.17
E	CHANGE 0.50 HOLE LOCATION AND ADD NOTE	RF	99.09.07
D	CHANGE SLOT SIZE AND LOCATION (TSR A1069)	CP	99.08.18
C	ADD POCKETS AND SLOTS FOR WELDING	DS	98.08.18
B	REMOVE POCKETS, ADD HOLE	DS	96.11.28
A	NEW ISSUE	DS	96.09.18
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>[Signature]</i>	D2576	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	STEP	1:3
DATE	07.08.15	<small>COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO14795

Purchase Order Date 9/1/2011

PO Print Date 9/1/2011

Page Number 1 of 1

Order From :

VC-ALP001

ALPINE NON-FERROUS FOUNDRY
8657 - 132ND STREET
SURREY, BC V3W 4P1
CA

Contact Name

Vendor Phone

604 596 8080

Vendor Fax

604 596 8045

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

CL/10/10/11

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2576-1P	Step (Casting Detail)	9/16/2011 Yes	50.00 Each	FedEx PI collect	\$17.7500	\$887.50

Special Inst: AS PER DWG D2576 REV. G
B73293

PO Total:

\$887.50

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

Change Nbr:

1

Change Date: 9/1/2011

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

ALPINE NON-FERROUS FOUNDRY8657-132ND STREET
SURREY, B.C. V3W 4P1**WORK ORDER**

Tel: (604) 596-8080

Fax: (604) 596-8045

Sold To: DART AEROSPACE
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
CANADA**Ship To:** DART AEROSPACE

Order Date		Purchase Order#	Due Date	Ship Via		Page
01-Sep-11		14795	16-Sep-11	FEDEX		1
Item#	Item Code	Description	Material	Ordered	B/O	Qty Ship
1 2	DART D2576	D2576 STEP CSTG		50		50

Comments

Castings&Patterns are property of Alpine until paid in full

PACKING SLIP

BECK ALUMINUM LEBANON

Division of Beck Aluminum Alloys LTD

24 KEYSTONE DRIVE

LEBANON, PA 17042

Telephone: 717/277-0300

Fax: 717/277-0310

3131687

Ship Date 06/07/11

Sold To:

RYPAC ALUMINUM RECYCLING LTD.
11849 TANNERY RD.
SURREY, BC V3V 3W8
CANADA

Ship To:

RYPAC ALUMINUM RECYCLING LTD.
11849 TANNERY RD.
SURREY, BC V3V 3W8
CANADA

CHEMICAL ANALYSIS - ELEMENTS LESS THAN 0.01% MAY NOT BE REPORTED

Customer	Ship Via	FOB	Terms
RYPAL	CPIL # 2337	LEBANON, PA	Net 30 Days
Purchase Order Number		Salesperson	Order Date
2508		JM	06/03/11
		Our Order Number	
		327247	

Item Number / Item Description

I535.2 PRIMARY ALUMINUM INGOT

Customer Item Code:

Dum 01/22

Heat #	LBS	SI	FE	CU	MN	MG	CR	NI	ZN	TI	PB	SN	SR	BE
X34590-075	1938	0.06	0.08	0.00	0.19	7.25	0.00	0.01	0.00	0.17	0.00	0.00	0.00	0.0043
X34590-076	1940	0.06	0.08	0.00	0.19	7.25	0.00	0.01	0.00	0.17	0.00	0.00	0.00	0.0043
X34590-077	1968	0.06	0.08	0.00	0.19	7.25	0.00	0.01	0.00	0.17	0.00	0.00	0.00	0.0043
X34590-078	2002	0.06	0.08	0.00	0.19	7.25	0.00	0.01	0.00	0.17	0.00	0.00	0.00	0.0043
X34590-079	1932	0.06	0.08	0.00	0.19	7.25	0.00	0.01	0.00	0.17	0.00	0.00	0.00	0.0043
X34590-080	2026	0.06	0.08	0.00	0.19	7.25	0.00	0.01	0.00	0.17	0.00	0.00	0.00	0.0043
X34590-081	1950	0.06	0.08	0.00	0.19	7.25	0.00	0.01	0.00	0.17	0.00	0.00	0.00	0.0043
X34590-082	1972	0.06	0.08	0.00	0.19	7.25	0.00	0.01	0.00	0.17	0.00	0.00	0.00	0.0043
X34590-083	1986	0.06	0.08	0.00	0.19	7.25	0.00	0.01	0.00	0.17	0.00	0.00	0.00	0.0043
X34590-084	1952	0.06	0.08	0.00	0.19	7.25	0.00	0.01	0.00	0.17	0.00	0.00	0.00	0.0043
X34590-085	2056	0.06	0.08	0.00	0.19	7.25	0.00	0.01	0.00	0.17	0.00	0.00	0.00	0.0043
X34590-086	2016	0.06	0.08	0.00	0.19	7.25	0.00	0.01	0.00	0.17	0.00	0.00	0.00	0.0043
X34590-087	1918	0.06	0.08	0.00	0.19	7.25	0.00	0.01	0.00	0.17	0.00	0.00	0.00	0.0043
X34590-088	1966	0.06	0.08	0.00	0.19	7.25	0.00	0.01	0.00	0.17	0.00	0.00	0.00	0.0043
X34590-089	1994	0.06	0.08	0.00	0.19	7.25	0.00	0.01	0.00	0.17	0.00	0.00	0.00	0.0043
X34590-090	1958	0.06	0.08	0.00	0.19	7.25	0.00	0.01	0.00	0.17	0.00	0.00	0.00	0.0043
X34590-091	2036	0.06	0.08	0.00	0.19	7.25	0.00	0.01	0.00	0.17	0.00	0.00	0.00	0.0043
X34590-092	1998	0.06	0.08	0.00	0.19	7.25	0.00	0.01	0.00	0.17	0.00	0.00	0.00	0.0043
X34590-093	2020	0.06	0.08	0.00	0.19	7.25	0.00	0.01	0.00	0.17	0.00	0.00	0.00	0.0043
X34590-094	1902	0.06	0.08	0.00	0.19	7.25	0.00	0.01	0.00	0.17	0.00	0.00	0.00	0.0043
X34590-095	1938	0.06	0.08	0.00	0.19	7.25	0.00	0.01	0.00	0.17	0.00	0.00	0.00	0.0043
X34590-096	1888	0.06	0.08	0.00	0.19	7.25	0.00	0.01	0.00	0.17	0.00	0.00	0.00	0.0043
Weighted Avg.	0.060	0.080	0.000	0.190	7.250	0.000	0.010	0.000	0.170	0.000	0.000	0.000	0.000	0.004

Special Requirements: INVOICE, PACKING LIST AND COA FAXED OR EMAILED ASAP.

Delivery Information: CPU, Van

Total 43356

CAUTION: INGOTS ARE SUBJECT TO THE FORMATION OF SHRINKAGE CAVITIES WHICH MAY ENTRAP MOISTURE. SUCH MOISTURE CAN CAUSE AN EXPLOSION HAZARD. TO MINIMIZE THIS HAZARD, ALL INGOTS MUST BE THOROUGHLY DRIED TO REMOVE ANY ENTRAPPED MOISTURE BEFORE CHARGING THEM INTO MOLTEN METAL

Authorized Signature

Date